

Date: Friday, 9/7/2007 10:14:53 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 34464	
Estimate Number : 10224	
P.O. Number : <u>N/A</u>	Part Number : D2143
This Issue : 9/7/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2143 REV. C1
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 33882	Material : <u>N/A</u>
Written By : <u>JA</u>	Due Date : 9/14/2007 Qty: 20 Um: Each
Checked & Approved By : <u>JA 07.09.07</u>	
Comment : Est C 06.05.18 Added inspection level 8 EC	
Est Rev:D Now on WaterJet 06-10-15 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0693 sf(s)/Unit Total : 1.3860 sf(s)

Material: 5052-H32-(QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Batch: M101875

SAD 07/09/09 (20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2143

Dwg Rev: C1Prog Rev: C1

2-Deburr if necessary

SAD 07/09/09 (20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/09 (20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

count
 07/09/10
 (20)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

07/09/10
 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 34464

Part Number: D2143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SB 08/01/07

20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/07

(+20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-01-11

(20)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9/1 08-01-14

(20)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS 08/01/15

(20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST10

AS 08/01/15

(20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/16

(20)

Job Completion



U 08-01-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

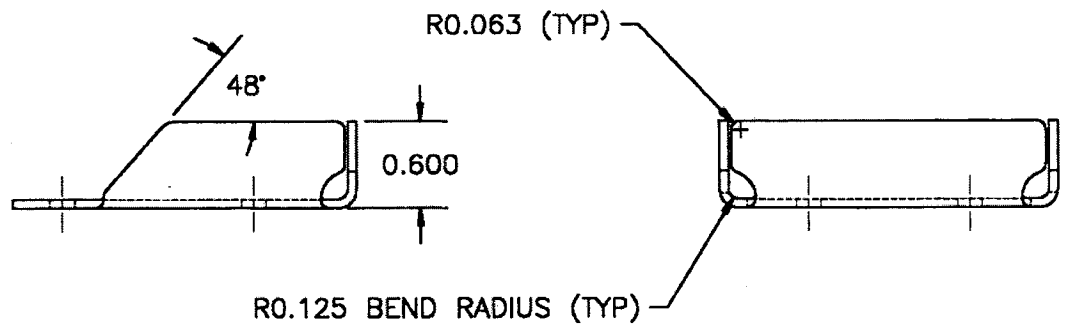
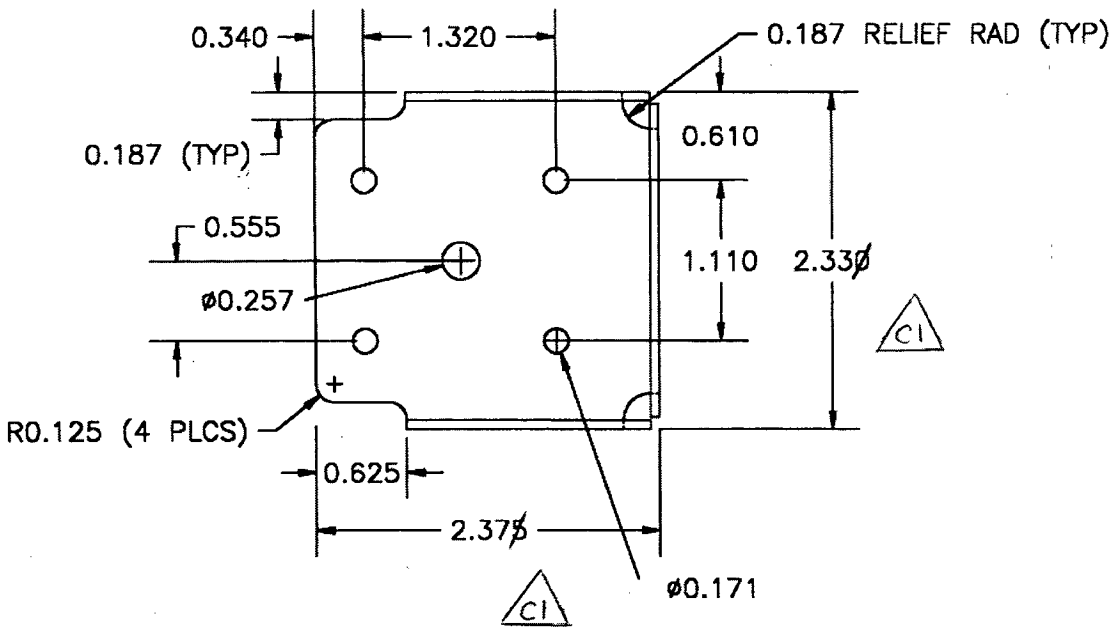
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
960620 BWS

DESIGN	J BRADLEY	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
CHECKED	BWS	APPROVED	BWS	DRAWING NO. D2143	SHEET 1 OF 2
DATE	92:07:10	TITLE	HINGE BRACKET	SCALE	
B	96.06.06	ADD	FLAT PATTERN		
C	96.06.13	MATERIAL WAS	2024-T3 .063 THICK		
CI	04.06.15	UPDATE	DIMENSIONS		



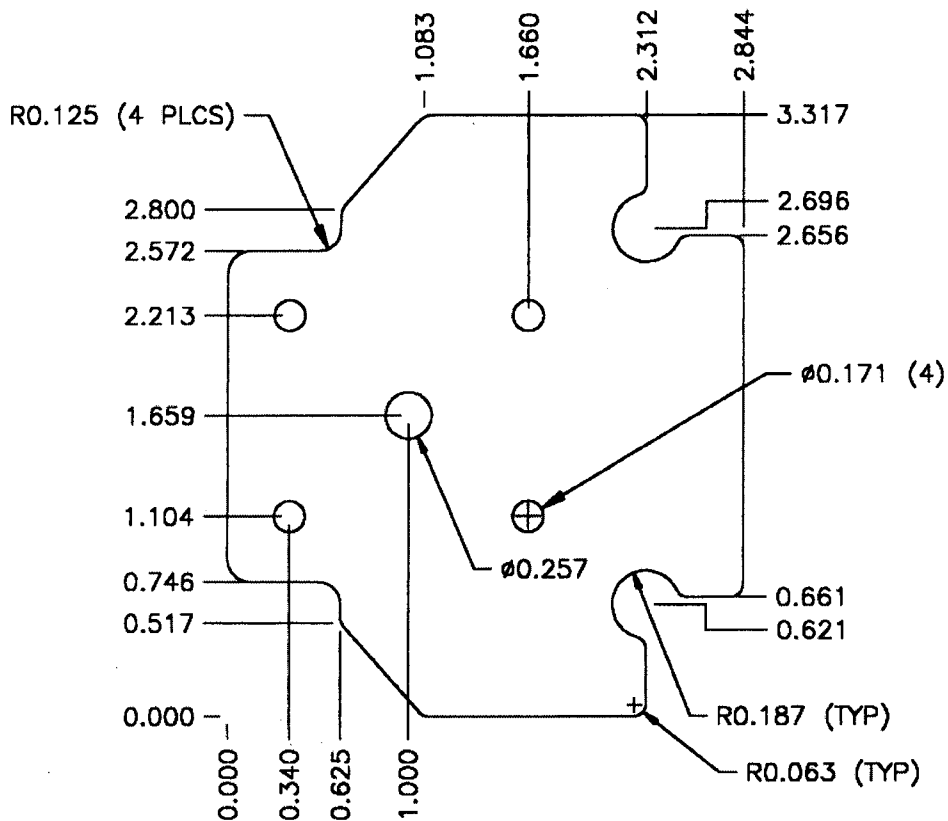
MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34464



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. a
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:10:18	HINGE BRACKET FLAT PATTERN	1:1	

RELEASED
965620 BW



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UNCONTROLLED COPY
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MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317